

Work Order ID 56217

February 16, 2010 12:54:35 PM

Page 1

Item ID: D3391-025

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *mc*

Date: 10-2-16

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	Rev H
-------	-------

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: *AA* & Dwg D3391-Rev: *H*

scribe batch # on fwd end at 90 degree

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

QA/AMP

IP

MB 10-02-24

1 - - AWM 10-2-25

8/10/24

FD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56217

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Page 3

Item ID: D3391-025

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

I-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 10-3-2

160

0.00



CNC Bend I

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 10-3-2

PTO

170

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

CP 10-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-025 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: / Date: 10/05/03
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>56217</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.03.04	160	Aft Aft bend is 4.620" re: process.	<u>CP</u> 10.03.04 per Q51642	Acceptable. Drag load increase moment increased but opposite buoyancy moment.	<u>CP</u> 10/5/04	<u>CP</u> 10.03.04 per Q51642	<u>CP</u> 10/6/04	

NOTE: Date & initial all entries

Work Order ID 56217

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Item ID: D3391-025

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

M101513

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



AC

1 11/10/5/5

DD 10-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 56217

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Item ID: D3391-025

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Start Date: 2/16/10 Start Qty: 1.00

Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Instal spacers as per dwg D3391
A/R Magnabond 6398 Batch: M 114021
exp. date: 11/6/30
cure time 12hrs as per QSI0015

11/10/5/5

230

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8/10/5/06

11

240

0.00



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

START TIME: 8:40
OVEN TEMPERATURE: 220°
FINISH TIME: 9:40

10-8-31.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC3- Inspect Part Finish

0.00

=> Hl 10/09/01



QC

Memo

0.00

Quality Control

260

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D3391
2-Install Aft Cap as per Dwg D3391
A/R Sikaflex-241/-291 M115114
Sikaflex expiry date: 11/01

270

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 10 09 01 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56217

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Item ID: D3391-025

Accept



Setup Start



Revision ID:

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Item Name: Aft Tube Assembly

Start Date: 2/16/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280



Packaging

Memo

0.00

Packaging

Identify as per dwg & Stock Location: W1061474

ml 10 09 01 ⑦

290



QC

Memo

0.00

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/09/02 fj

mf

10-9-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 16, 2010 12:54:30 PM

Page 1

Work Order ID: 56217



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
IPP Rev:C 06-03-28 Update Manuf. Instructions JLM [|||||]
IPP rev D 07.03.20 revF dwg EC
IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D6014-090



Manufactured No 100 Each 14.0000 1.0000



ALUMINUM EXTRUSION

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

14

42768

14

D3670-4-200



Manufactured No 230 Each 95.0000 4.0000



SPACER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

95

48198

10

48269

85

EX 10-02-23

B 57349

④ 4/10/5/5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 16, 2010 12:54:30 PM

Work Order ID: 56217



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM 1111111
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No 270 Each 55.0000 1.0000



Aft Cap

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP6 29

52663 29

Main Warehouse

fp7 13

52663 13

Main Warehouse

ST 13

46327 4

48109 9

D3537-1 Manufactured No 270 Each 153.0000 1.0000



Wearpad

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 74

48288 2

55465 72

Main Warehouse

FP17 79

51678 1

51679 78

February 16, 2010 12:54:30 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 16, 2010 12:54:31 PM

Work Order ID: 56217



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM [illegible]
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3537-7 Manufactured No 270 Each 17.0000 1.0000



Wearpad



Handwritten: 10/09/01

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 17

45408 6

46346 11

D3553-1 Manufactured No 270 Each 12.0000 1.0000



Gasket



Handwritten: 10/09/01

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 12

33868 12

B 56568

Handwritten: 10/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 16, 2010 12:54:32 PM

Work Order ID: 56217



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

D3553-3 Manufactured No 270 Each 61.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 60

53480 60

Main Warehouse

ST 1

47206 1

D3672-1 Manufactured No 270 Each 1,704.000 2.0000



Phenolic Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1204

39275 19

42329 5

47628 180

52505 1000

Main Warehouse

ST117 500

51674 500

x1 H 10/09/01

x2 H 10/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

February 16, 2010 12:54:32 PM

Work Order ID: 56217



Parent Item: D3391-025



Parent Item Name: Aft Tube Assembly

Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM [111][11]
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 Purchased No 260 Each 1,908.000 14.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1908

110511

1908

M 114723

x14 H 10109101

ALS4-1032-225 Purchased No 270 Each 6,296.000 12.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6296

107441

16

110768

6280

x12 H 10109101

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM [] [] [] []
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 270 Each 1,213.000 6.0000



BOLT

X

Warehouse Loc Qty Loc Code

Location

Main Warehouse

Location	Qty
ST	1213
112314	13
112720	12
112724	3
112829	1
112991	2
113121	64
113226	344
113422	84
113644	490
113749	200

M114941

X

x6 JH 10/09/01

AN3C5A Purchased No 270 Each 564.0000 4.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

Location	Qty
ST	564
111424	8
111707	69
112314	1
113121	206
113149	274
113644	6

M115015

x4 JH 10/09/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56217



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Start Date: 2/16/10

Required Date: 2/22/10

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased

No

270

Each

388.0000

10.0000



washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

1115600

Y10 2H 10109101

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56217
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.503	✓			
88.93	+/-0.030	88.940	✓			
44.995	+/-0.030	44.995	✓			
Ø3.200	+/-0.010	3.200	✓			
88.93	+/-0.030	88.93	✓			
Ø3.750	+/-0.010	3.750	✓			
30° x 160" chamfer	+/-0.010	30° x 160"	✓			

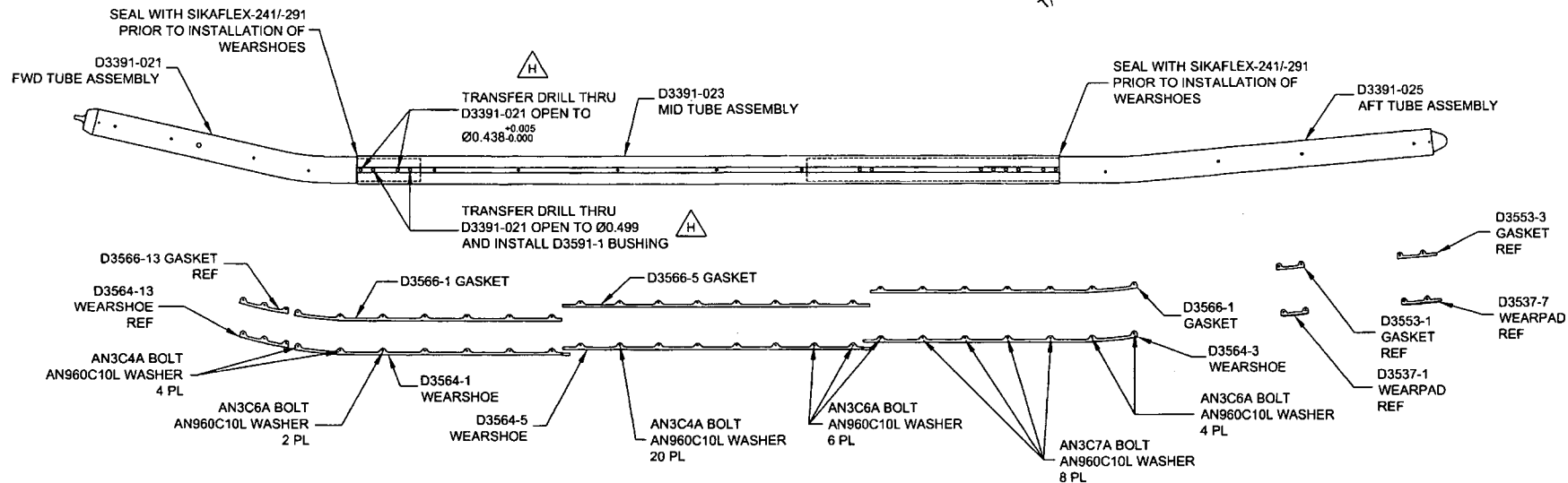
Measured by: Q.M./MB	Date: 10-02-24
Audited by: Q.M./MB 8	Date: 10/02/26

HAAS Section						
1.526	+0.000/-0.030	1.525	—			
7.500	+/-0.010	7.495	—			
27.750	+/-0.010	27.750	—			
31.750	+/-0.010	31.750	—			
35.250	+/-0.010	35.250	—			
3.300	+/-0.010	3.310	—			
0.200	+/-0.010	.192	—			
3.520	+/-0.010	3.527	—			
0.687	+0.010/-0.000	.687	—			
R0.062	+/-0.010	R.062	—			
Ø0.484	+0.005/-0.001	Ø.488	—			

Measured by: Q.M./MB	Date: 10/02/28
Audited by: J.P.	Date: 10/03/02

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	

#36217



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST





QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

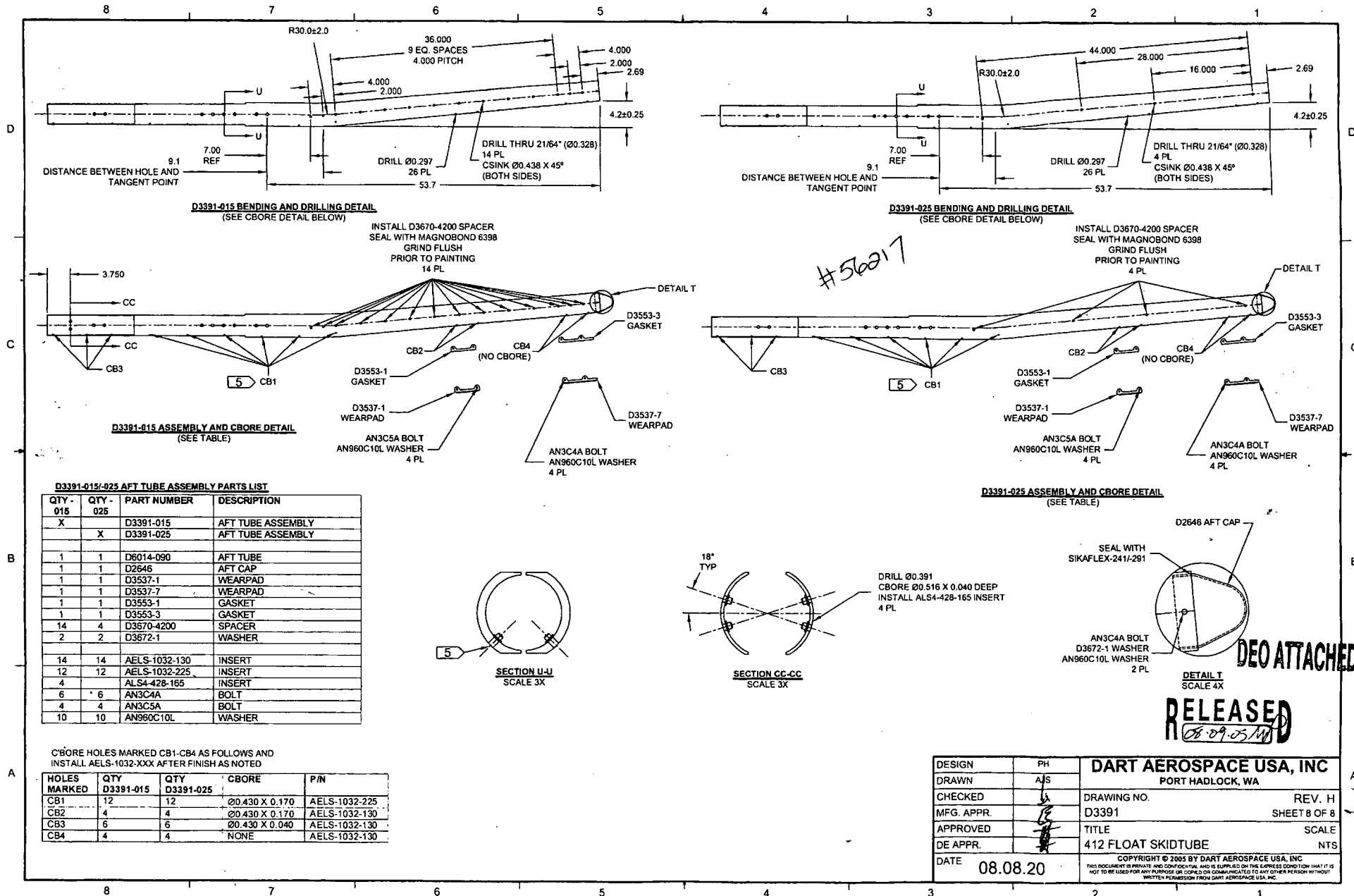
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	


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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>h</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>		DE APPR. <i>h</i>		
DATE 09.09.23	DATE <i>09.09.24</i>	DATE <i>09/09/25</i>	DATE <i>09/09/30</i>		DATE <i>09/09/30</i>		

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

#56217

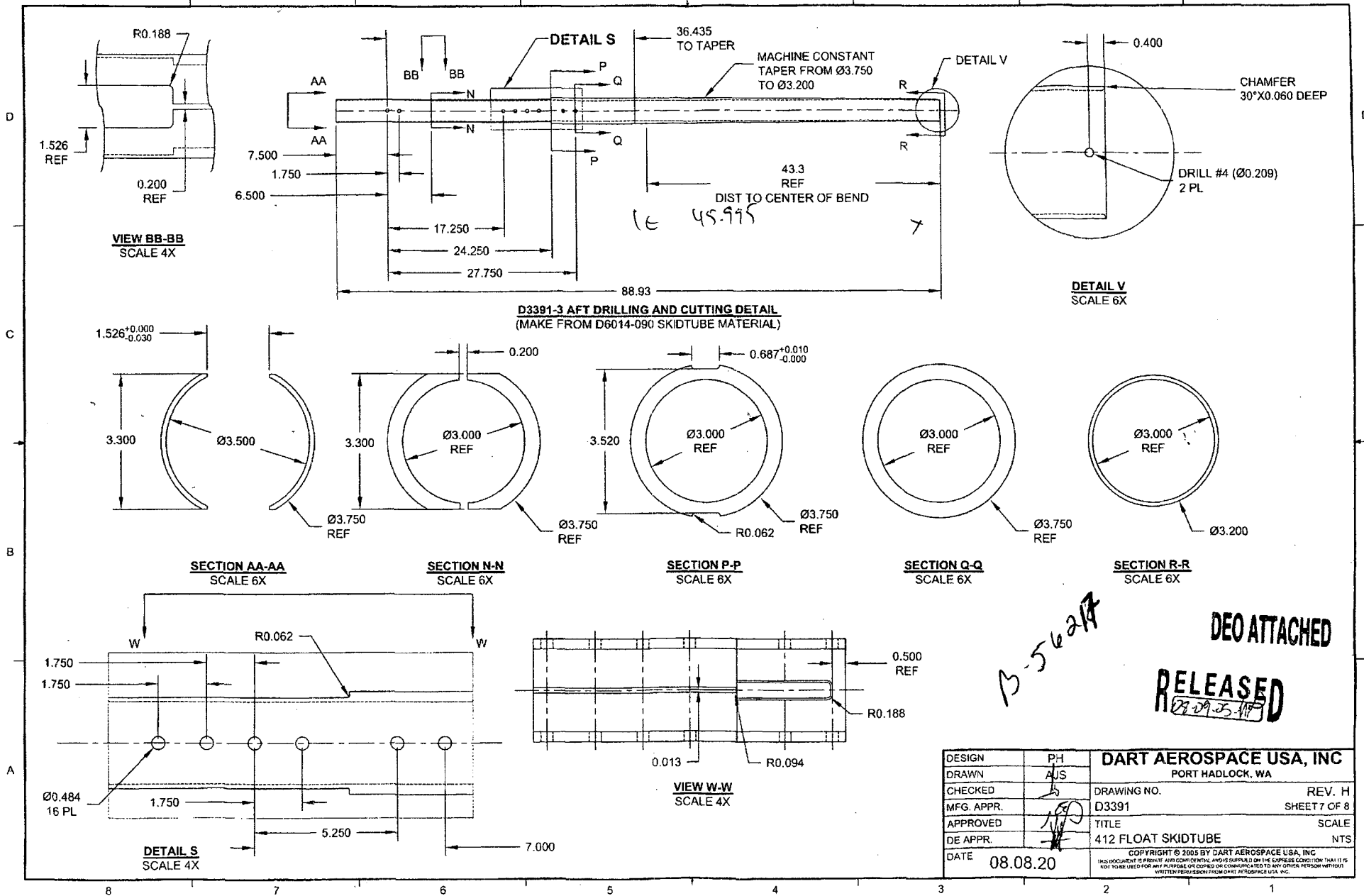
RELEASED
 2010-02-02

MP

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B-56217

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MFG. APPR.		D3391	SHEET 7 OF 8
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